



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2939-1BL
Job Sheet 167810



split
5

Part No: D2939-1BL

Job Qty: 10 ea

Part Name: Saddle LH In, 206



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/7/17

Job Tracking No:

Due Date: 11/24/17

Created By: Victoria Michaud-Febrille

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	11/23/17	11/23/17	0.00	0.00	Start Up Machining		FK 17-12-2
100	CNC Vertical Machining	10 pcs	11/23/17	11/23/17	0.54	14.08	HAAS 1		FK 17-12-3
110	Mill Conv	10 pcs	11/23/17	11/23/17	0.00	0.00	Mill Conv 1		FK 17-12-3
120	QC	10 pcs	11/23/17	11/23/17	0.00	0.00	QC1		FK 17-12-3
130	QC	10 pcs	11/23/17	11/23/17	0.00	0.00	QC8		OK 17/12/12
140	HandFinish	10 pcs	11/23/17	11/23/17	0.00	0.34	HandFinish1		2017-12-12 JSC
150	SprayPaint	10 pcs	11/24/17	11/24/17	0.00	1.03	Spray Paint		DAS
160	QC	10 pcs	11/24/17	11/24/17	0.00	0.00	QC14		PD/11
170	Packaging	10 pcs	11/24/17	11/24/17	0.00	0.00	Packaging3	57392	9-88
180	QC21-SA	10 Ea	11/24/17	11/24/17	0.00	0.00	QC21		Umg

Part Op 100 - Program part number and batch number.

Descriptions: 110 - Machine Keyway and inspect per attached dimension sheet

150 - ***MASK ALL HOLES AS PER PAR16-484***

DAS
13
9-88

DEC 14 2017

PRO: 38646

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-001	10	29	0	0

F164403 (S016547)

Part Specifications

Specifications could not be found.

Plex 11/7/17 8:24 AM dart.Michaud-Febrille.Victoria

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____

DISPOSITION

AGAINST DEPARTMENT/PROCESS

ewor
Scra
e-as-
rove

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Mfg Date: 12/02/17
Job No: 167810

/ater Jet
ig. Coord.
ackaging
Supplier

Engineering
Quality
Other

MRB (QSI042) Approval

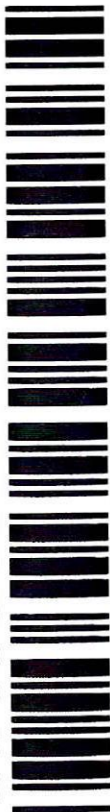
Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval

Mfg Date: 12/02/17
Job No: 167810

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

DART
AEROSPACE
S016548



Saddle LH In, 206

PART NO: D2939 - 1BL

Revision:

Operation: Start up Operation

Change No:

DART
AEROSPACE
S016548



Saddle LH In, 206

PART NO: D2939 - 1BL

Revision:

Operation: Outsource

Change No:

Past Expiry Date ☐Misidentified ☐Manufacturing Process ☐Past Due ☐OTHER: ☐☐ Drill Holes☐ Misaligned/off center

☐ Positioned Wrong
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Drawing
☐ Finish
☐ Misread
☐ Turning Sequence

DART AEROSPACE LTD	Work Order:	167810
Description: 206 Saddle, Inboard, Left side	Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.115	.116	.116	.115		
B	0.100	0.140		.114	.114	.113	.114		
C	0.100	0.140		.117	.118	.117	.117		
D	0.210	0.230		.224	.225	.224	.224		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.511	.511	.511	.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.237	.238	.237	.237		
N	0.100	0.140		.121	.121	.121	.121		
O	0.540	0.560		.549	.548	.548	.549		
P	0.490	0.510		.500	.501	.500	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.741	2.742	2.742	2.743		
S	0.240	0.270		.255	.255	.255	.254		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.250	1.270		1.260	1.260	1.260	1.260		
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject				✓	✓	✓	✓		

Measured by:	FEK
Date:	17-12-2

Audited by:	amf
Date:	17/12/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	167810
Description: 206 Saddle, Inboard, Left side	Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	7	8		
A	0.100	0.140		.115	.117	.115	.115		
B	0.100	0.140		.114	.116	.112	.113		
C	0.100	0.140		.119	.118	.117	.117		
D	0.210	0.230		.224	.224	.223	.224		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.511	.511	.511	.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.238	.238	.237	.236		
N	0.100	0.140		.121	.121	.120	.121		
O	0.540	0.560		.548	.548	.548	.548		
P	0.490	0.510		.500	.500	.499	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.743	2.743	2.743	2.744		
S	0.240	0.270		.255	.255	.255	.255		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.250	1.270		1.260	1.260	1.260	1.260		
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject				/	/	/	/		

Measured by:	F.R.
Date:	17-12-12

Audited by:	mf
Date:	17/12/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 167810
Description: 206 Saddle, Inboard, Left side	Part Number: D2939-1
Inspection Dwg: D2939 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	9	10	3	4		
A	0.100	0.140		.115	.115				
B	0.100	0.140		.113	.113				
C	0.100	0.140		.118	.117				
D	0.210	0.230		.225	.225				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.511	.511				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.313	.313				
M	0.235	0.240		.237	.238				
N	0.100	0.140		.121	.121				
O	0.540	0.560		.548	.548				
P	0.490	0.510		.500	.500				
Q	3.715	3.725		3.720	3.720				
R	2.720	2.760		2.744	2.744				
S	0.240	0.270		.255	.254				
T	0.100	0.180		.135	.135				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.316	.316				
X	1.250	1.270		1.260	1.260				
Y	1.565	1.585	DT8695 A/B	1.575	1.575				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject				/	/				

Measured by: F.R.
Date: 17-12-3

Audited by: [Signature]
Date: 17/12/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	[Signature]